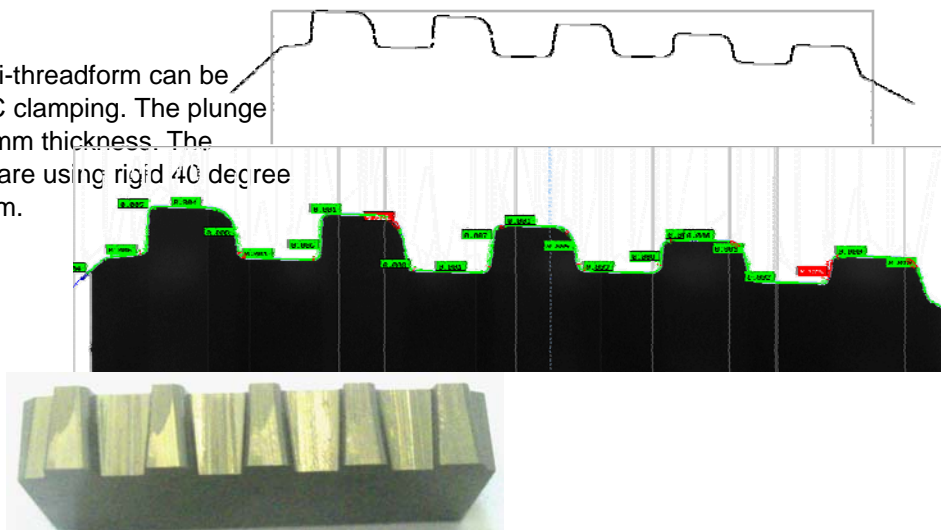
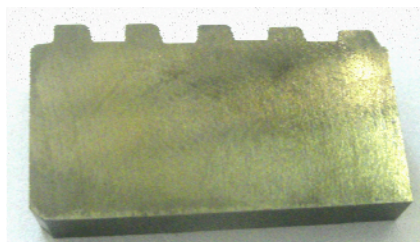









## Multithread insert 1-sided for tubes

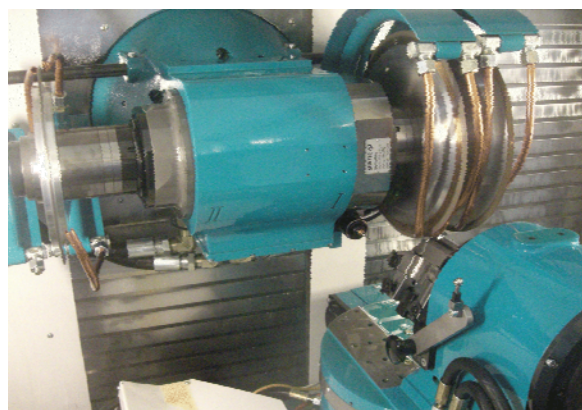
A08-010

The onesided Threadinsert with multi-threadform can be ground in one setup in standard RPC clamping. The plunge roughing operation uses a 1A1 of 2 mm thickness. The pregrinding and finishing operations are using rigid 40 degree V-shaped wheels of diameter 300 mm.



### 1. Cycletime for Production

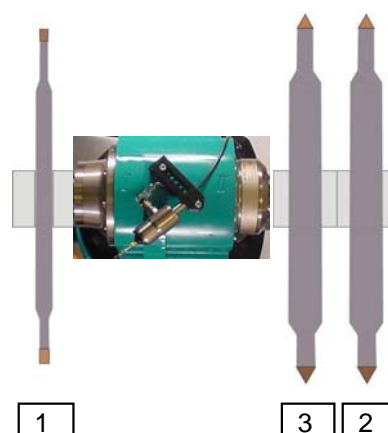
Workpiece: L 25.4 x 15.6 x 5.185 Material CARBIDE				
Operations				
Feed [mm/Min]	20	25	20	9000
Power [kW]	2	1	2	1
Cutting feed [m/s]	24	24	24	
Used wheels				
Grinding time [s]	304	124	142	18
Total cycle time	9 Min 48			



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14A1 Ø250 D64
2	14V1 Ø300 D76V40°
3	14V1 Ø300 D64V40°



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM  
Control: Fanuc 160i/310i  
Accessories: STL6051

Coolant: Synthetic Oil, pressure 6 bar  
Software: Quinto 5

Responsible engineer: OP. 4.6.10

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